



IMPROVEMENTS IN AND RELATING TO THE FILLING OF EXPLOSIVE  
ORDNANCE

This invention relates to the field of the filling of ordnance with explosive  
5 materials, and more specifically to the use of static mixing in the filling process.

BACKGROUND OF THE INVENTION

Traditional methods used for filling ordnance with polymer bonded  
explosive (PBX) ~~utilise~~ utilize a filling process based on the combination of  
10 usually two materials, namely an explosive mixture (pre-mix) and hardener,  
which are mixed together immediately prior to use in filling the chosen  
ordnance.

In a typical application of the mixing and filling process, a pre-mix of  
explosive such as, for example, PBX is produced and typically mixed with a  
15 hardener (i.e., IPDI), the combined mixture being mixed together in a high  
shear mixer.

Once mixed, the bowl of the high shear mixer containing the fully mixed  
PBX composition is fitted with a pressure plate apparatus and cover, then  
raised to an appropriate filling height on a ~~specialised~~ specialized bowl lift.

20 Once elevated into position, the bowl of fully mixed PBX composition is  
~~pressurised~~ pressurized using an inert gas (i.e., nitrogen) for the purposes of  
aiding the dispensing of the fully mixed PBX composition through a system of  
pipes to the ordnance filling position.

Ordnance to be filled is typically placed in a vacuum chamber and a  
25 filling attachment from the bottom outlet valve of the mixer bowl containing the  
fully mixed PBX composition is attached to the chamber. Typically, the vacuum  
will be evacuated to <100 millibars.

The vacuum provides the physical motivation for the fully mixed PBX  
composition to flow into the ordnance when the valve from the bottom outlet of  
30 the mixer bowl is released. The quantity of fully mixed PBX composition  
introduced to the cavity within the ordnance is usually judged visually, and when

sufficiently filled, the vacuum to the chamber is released and the filled component removed ready for the introduction of the next ordnance component to be filled.

5 The traditional method of filling ordnance as described above suffers from a number of problems associated with the finite 'pot life' time of the fully mixed PBX composition and the fact that once the various chemicals have been combined, the 'pot life' time defines the period within which the filling process must be completed before the PBX composition cures and can no longer be used in the process (i.e., would solidify within the pipe work).

10 The 'pot life' is typically in the order of two hours and in instances where there are no problems associated with a particular batch of components, then the mixing of PBX and hardener (IPDI) in a bowl and the subsequent dispensing of the fully mixed PBX composition into ordnance can be achieved relatively quickly. However, if for any reason (for example, mechanical  
15 breakdown, etc. [[etc]]) the filling process has to be interrupted or indeed suspended, then the whole of the fully mixed PBX composition has to be purged from the mixing and filling apparatus, the purged material being lost to waste.

## 20 SUMMARY OF THE INVENTION

The invention described herein provides for apparatus and a method for the mixing of explosive compositions and the subsequent filling of ordnance without being subject to the problems associated with having to mix and use a specific quantity of explosive composition within a limited 'pot life' period.

25 Accordingly, there is provided apparatus for the mixing of explosive materials, comprising:

- a reservoir of pre-mixed explosive material,
- a reservoir of hardener material, and
- a static mixer [[means]],

30 wherein each of [[said]] the reservoirs ~~having pipe means~~ has piping for conveying [[said]] the pre-mix explosive material and hardener material

respectively into the inlet of a static mixer, ~~means, the~~ whose outlet of said static mixer ~~means being~~ is connected to ~~[[means]]~~ apparatus for effecting the filling of ordnance components.

Preferably the ~~pipe means~~ piping for conveying each of said materials  
 5 are not linked or combined until they reach the inlet of said static mixer ~~[[means]]~~.

Preferably the ~~[[means]]~~ apparatus for filling each of ~~[[said]]~~ the ordnance components with ~~[[said]]~~ the final mixed explosive material will be controlled such that the respective pre-mix explosive material and the hardener materials  
 10 are introduced to the static mixer ~~[[means]]~~ on demand, thereby ~~minimising~~ minimizing the amount of combined explosive material in ~~[[said]]~~ the apparatus to that contained in the static mixer ~~[[means]]~~ itself and the associated pipe-work used to connect the output of said static mixer unit to the ordnance for filling.

15 ~~The invention is now described by way of example only with reference to the following drawing in which~~

Other objects, advantages and novel features of the present invention will become apparent from the following detailed description of the invention when considered in conjunction with the accompanying drawings.

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#### BRIEF DESCRIPTION OF THE DRAWINGS

The single Figure ~~[[1]]~~ is a diagrammatic representation of an explosive mixing and ordnance filling apparatus in accordance with the invention.

#### 25 DETAILED DESCRIPTION OF THE INVENTION

Referring to the Figure, 1 ~~shows~~ a pre-mix explosive material 2 is shown in a high shear mixing bowl assembly 4 ~~wherein~~ in which the mixing of the pre-mix explosive material 2 has been completed~~[[, the]]~~. The pre-mix explosive material 2 ~~being held~~ within the mixing bowl assembly 4 is subjected to  
 30 controlled pressure by the action of a hydraulic cylinder 6 and ram 8 assembly. ~~Hydraulic~~ A hydraulic cylinder ~~control means~~ controller 10 is ~~[[shown]]~~ provided

for controlling the flow of pre-mix explosive material 2 through the exit valve 12 and onwards through the pre-mix explosive material pipe work 14.

Hardener material 16 is depicted housed within a header tank 18 having pipe work 20 leading to a pump ~~[[means]]~~ 22 to provide the controlled supply of  
 5 hardener material 16 through the pipe work 24.

A static mixer ~~[[means]]~~ 26 is provided having pipe work 14 and 24 at its inlet port 28 and an outlet port 30 and corresponding pipe work 32 for conveying final mixed explosive material 34 to ordnance filling stations 36.

In use, ordnance 38 to be filled with final mixed explosive composition 34  
 10 are positioned at ordnance filling stations 36. When the ordnance is correctly in position 38 and the associated fill-to-level ~~control apparatus~~ controller 42 is connected ~~(not shown)~~. A, a signal from the process control 40 to initiate the filling operation is activated. A demand signal is received by the fill-to-level controller 42 from ~~[[the]]~~ a non-contact level ~~sensor~~ controller 46 indicating that  
 15 the ordnance is not filled and accordingly the fill-to-level controller 42 sends a demand signal to the pre-mix explosive material hydraulic cylinder controller 10 and the hardener material pump 22.

The pre-mix explosive material 2 and hardener material 16 are conveyed through their respective separate pipe works ~~[[12]]~~ 14, 24, ~~both materials 2, 16~~  
 20 ~~being and are~~ introduced individually to the inlet 28 of the static mixer ~~[[means]]~~ 26. It is important to note at this point that in accordance with the invention, the point at which the pre-mix explosive material 2 and hardener material 16 are first combined is substantially at the inlet port 28 of the static mixer means 26 thereby providing a distinguishing feature over the prior art in which the two  
 25 materials are normally combined in the mixing bowl, thereby starting the 'pot life' for the combined explosive material within the mixing bowl 4.

At the inlet 28 of the static mixer ~~[[means]]~~ 26 the pre-mix explosive material 2 and hardener material 16 are forced through a number of static mixing ~~blade means~~ 4 blades ~~(not shown)~~, thereby mixing the two materials 2,  
 30 16 together. Such static mixing ~~[[means]]~~ blades are known within the confectionery and food industries and typically comprise a plurality of ~~blade means~~ blades arranged in a 'corkscrew' ~~[[type]]~~ manner, which promotes the

effective mixing together of two or more materials when forced through the mixer.

Additionally, the use of a static ~~mixing means~~ mixer provides for simplified cleaning of the apparatus following the completion of an ordnance filling run, thereby further reducing the inherent complexity and time required for purging and cleaning using state of the art apparatus.

The combined final explosive mixture 34 passes through the static mixer ~~[[means]]~~ exit port 30 and along the pipe-work 32 arriving at the ordnance filling stations 36. ~~At the filling stations 36~~ There, the flow of combined explosive mixture 34 into the waiting ordnance 38 is controlled via pinch valves 44, ~~[[the]]~~ whose operation of said pinch valves 44 ~~being~~ is controlled so as to limit the volume of combined final explosive mixture 34 introduced into the ordnance 38. A vacuum source 48 is provided to encourage the filling of the volume within the ordnance.

The control of the valves 44 (typically pinch valves) to enable the accurate filling of the ordnance may be effected either by a human operator directly controlling a valve 44 or by a ~~mechanised~~ mechanized system, which for the purposes of this specific embodiment ~~utilises~~ utilizes a non-contact level controller 46 which forms part of an integrated control system 10, 40, 42, 46, 48.

When the non-contact level controller 46 senses that ordnance 38 requires filling with combined final explosive mix 34, ~~[[then]]~~ a signal is sent to the fill-to-level controller 42 which in turn initiates the flow of both pre-mix explosive material 2 and hardener material 16 through the static ~~mixing means~~ mixer 26 ~~[[42]]~~ and via the outlet pipe work into the waiting ordnance 38. When the non-contact level controller 46 senses that any of the ordnance 38 has reached its fill limit, then a signal is sent to the fill-to-level controller ~~[[2]]~~ 42 to stop the flow of materials 2 and 16.

The non-contact level controller 46 may comprise, for example, an optical sensor, a fibre optic sensor, a laser sensor or an LED sensor.

Using the above stated control ~~means thereby~~ system provides for both apparatus and a method of filling ordnance 38 with combined final explosive

mixture 34 in a controlled manner, ~~utilising~~ utilizing apparatus that prolongs the 'pot life' of ~~[[said]] the~~ combined final explosive material 34. This ~~resulting in~~ technique significantly ~~[[less]]~~ reduces waste explosive material to be disposed of, and additionally simplifies the cleaning of the system by ~~minimising~~ minimizing the number of elements of the apparatus actually exposed to combined final explosive material 34. The method of filling ordnance 38 using such apparatus and ~~control means~~ controllers can provide an automated ordnance filling system.

In order to clean the apparatus as described, the action of pumping pre-mix explosive material 2 (or an alternative compatible inert material) through the apparatus in the absence of any hardener material 16 will be substantially sufficient to purge the system of any combined final explosive material 34, thereby reducing the complexity, time and danger level associated with purging state of the art apparatus within which combined final explosive material has been allowed to cure.

In addition to the elements described ~~in the specific embodiment of the invention above,~~ a number of measuring sensors and safety devices would also be incorporated into the apparatus as shown in the Figure ~~[[1]]~~, namely a flow meter sensor 50, a pressure sensor 52, temperature probes 56, a pressure switch 58 and a safety burst disc 60. Such sensors and safety devices are known in the art and are included in the specific embodiment by way of example to illustrate the industrial application of the invention.

Additionally, a ~~colour~~ color agent or dye can be added to the hardener material 16 such that it will be possible to monitor the amount of hardener 16 present in the final combined explosive mixture 34. The analysis of the ~~colour~~ color of the combined mixture 34 may be made by ~~utilising~~ utilizing a ~~colour~~ color sensor means located after the mixing process, calibrated to ~~recognise~~ recognize particular ranges of ~~colour~~ color as indicating sufficient percentage of hardener in the combined material 34, or by use of a viewing window in the pipe work containing the combined mixture 34 to allow for visual inspection of the ~~colour~~ color of ~~[[said]] the~~ mixture 34.

It is to be noted that the hydraulic cylinder 6 and ram 8 assembly is far safer than using displacement pumps to pump the pre-mix explosive material to the static mixer 26. It is also to be noted that the pre-mix explosive material is not pumped to the static mixer as this may be too dangerous.

5        As an alternative, instead of ~~to the flow meter 50~~ being located in the pre-mix explosive material pipe work 14, the flow meter may be located in the hydraulic line to the hydraulic ram 8. In this case, the flow meter accurately measures the displacement of the ram 8 and hence the mass flow of the pre-mix explosive mixture. This alternative is of particular use when the pre-mix  
10 explosive material is too viscous and inaccurate flow readings are obtained when the flow meter is in the pre-mix explosive material pipe work 14.

Other advantages of the invention will be readily apparent to those skilled in the art and the substitution of elements for mechanical equivalents and adaptation of the process using different materials and the like should be  
15 construed as being comprised within in the inventive concept as claimed.

References to ordnance in the above specification and claims shall be construed as non-limiting and in respect of the invention shall include without limitation shells, mortars, rockets, projectiles and any other ordnance or containers which are required to be filled with a combined final explosive  
20 mixture.